

Date: Tuesday, 3/11/2008 7:57:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG		
Job Number	: 37746					
Estimate Number	: 10256					
P.O. Number	:		Part Number	: D22303		
This Issue	: 3/11/2008	S.O. No. :	Drawing Number	: D2230 REV F		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type	MACHINED PARTS	Drawing Revision	: F	
Previous Run	: 37152		Material	:		
Written By	:		Due Date	: 3/31/2008 Qty: 160 Um: Each		
Checked & Approved By	: <u>KJ</u> 08/03/11					
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D2423	Lug Extrusion		
		Comment: Qty.: 0.0717 f(s)/Unit Total : 11.4744 f(s) Lug Extrusion D2423 Batch: <u>B33310</u> C Lo 8/03/12	(160)	11.4744
2.0	BAND SAW	BAND SAW		
		Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: <u>N/A</u>	issue R10 5896 sper ding REV.F C Lo 8/03/12	(160)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine.	<u>N/A</u>	R 8/3/08 (160)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>N/A</u>	
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	<u>aspose</u>	coates C 08/03/11 (160)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37746		Part Number: D22303
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble and deburr rough edges after tumbling		<i>SP08/03/31 160</i>
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>BL 08-04-01</i>
8.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		<i>BL 08/04/01 + 160</i>
9.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3		<i>M 107550 160</i>
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT		<i>M-1 08/04/02</i>
11.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 476		<i>8/4/4 SG 160X</i>
12.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<i>08/04/08/11</i>
Job Completion		<i>mf 08-04-07</i>
		<i>V</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

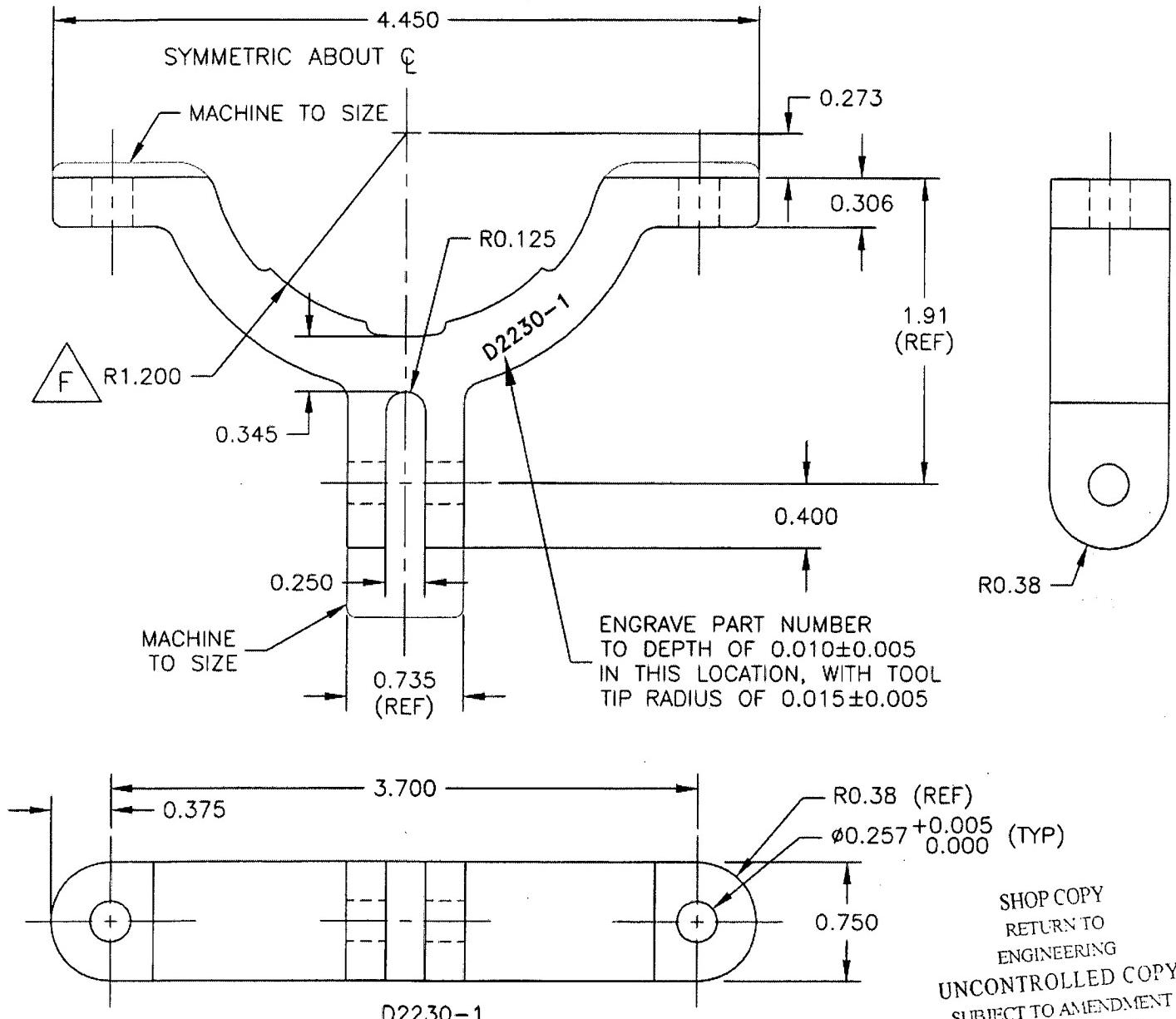
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	#	DRAWING NO. D2230
DATE			REV. F SHEET 1 OF 2
99.12.13			TITLE MOUNTING LUG
			SCALE 1:1

RELEASED
99.12.21 DS

C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



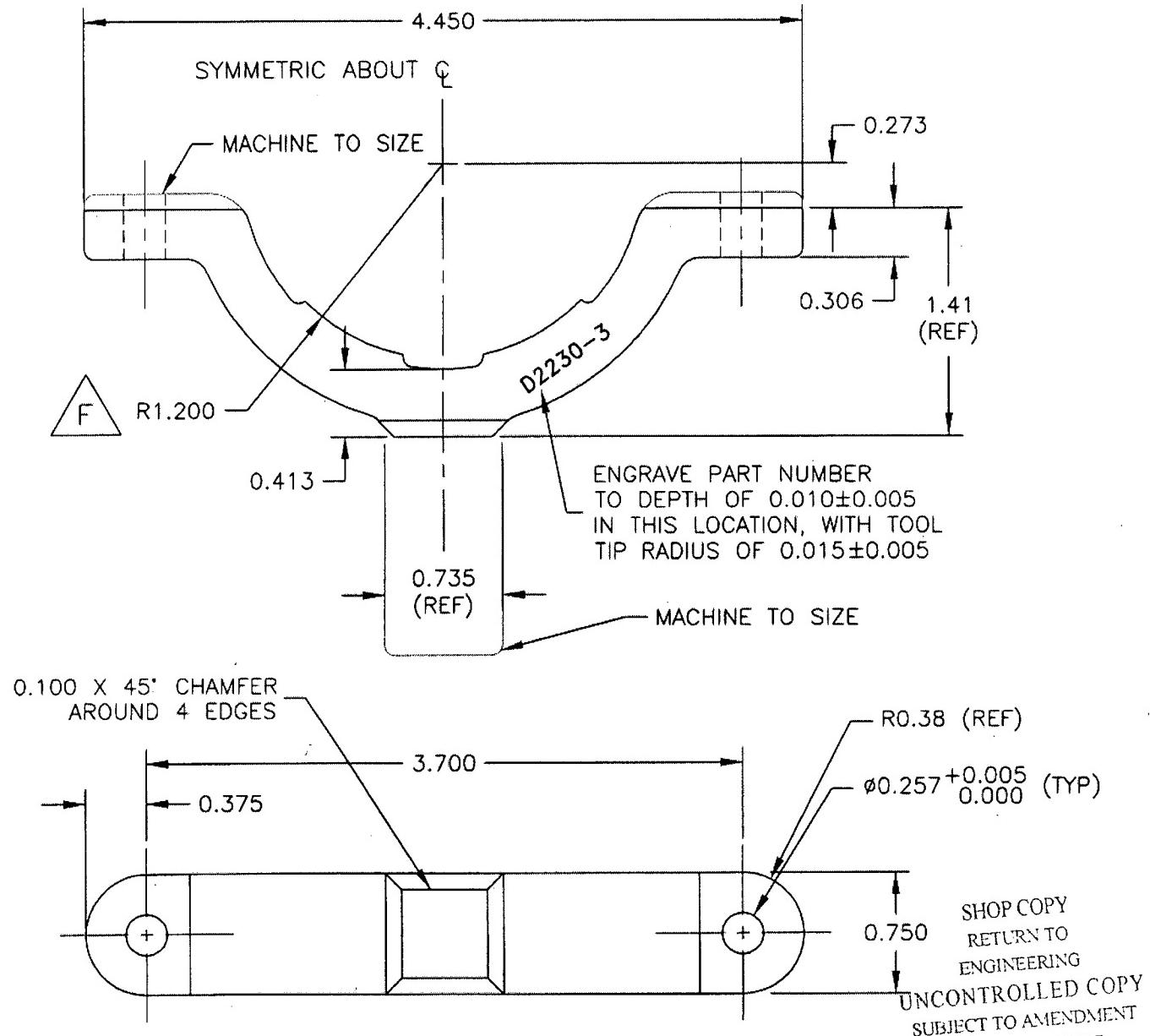
COPY ISSUED
NO

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		TITLE MOUNTING LUG

REV. F
SHEET 2 OF 2
SCALE
1:1

RELEASED
49.12.21 DS

60
120



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CERTIFICATE OF CONFORMITY**SHIPPED TO:****SOLD TO:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
160	D2230-3	Lug B37746	5896

MATERIAL supplied by DART D2423 B33310



We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in cursive script, appearing to read "Shigi Walz".

Shigi Walz

Vankleek Hill, March 28, 2008